

Date: Tuesday, 9/4/2007 11:30:17 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HEAT OUTLET DEFLECTOR
Job Number : 34416	
Estimate Number : 12156	
P.O. Number : N/A	Part Number : D34725
This Issue : 9/4/2007	Drawing Number : D3472 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 31537	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 10/4/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 6 Um: Each
Comment : est rev. A 06.02.02 new issue EC	
est rev. B 06.03.29 added alodine EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 1.1428 sf(s)/Unit Total : 6.8569 sf(s)

2024-T3 .063 sheet

Batch: M101022

SAD 07/09/10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

Cut as per Dwg D3471

Dwg Rev: A

Prog Rev: A

SAD 07/09/10

6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/10

6

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

count  
 SAD 07/09/10 (x6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2- Buff out scratches

SAD 07/09/12 (6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/15/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 34416

Part Number: D34725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

U 07-09-18 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

coats  
07-09-18 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07-09-18 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-09-18 (6)

Job Completion



U 07-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

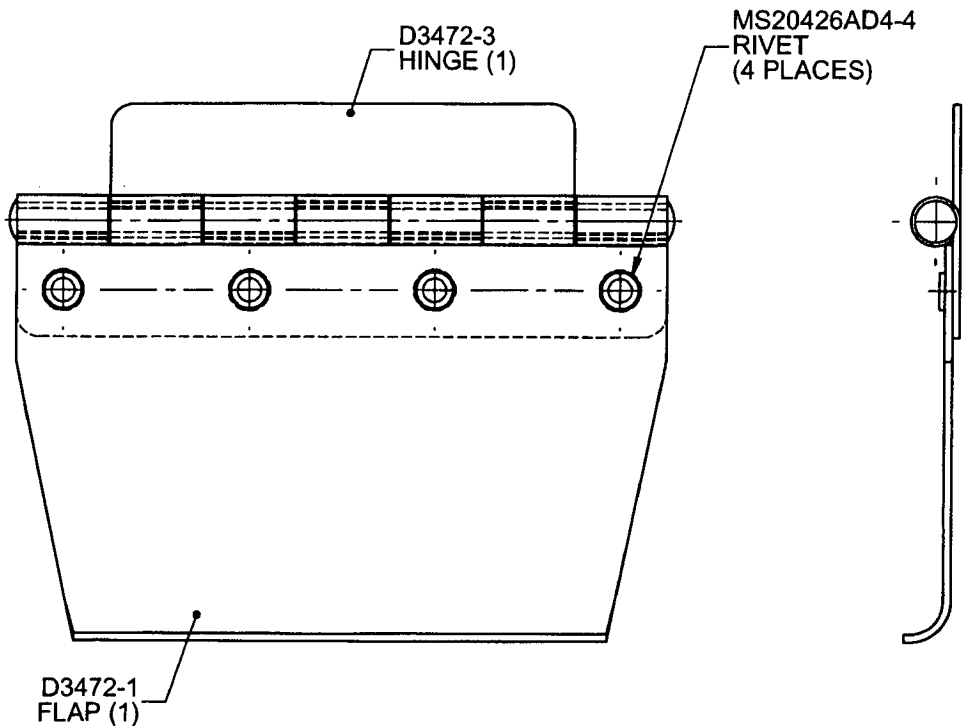
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3472</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.17</b>		TITLE <b>HEAT OUTLET DEFLECTOR</b> SCALE 1:1	
A	06.01.17	NEW ISSUE	

06.04.03 *[Signature]***D3472-041 CABIN HEAT OUTLET DEFLECTOR**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34416

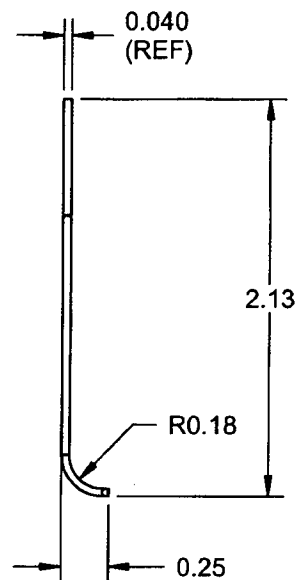
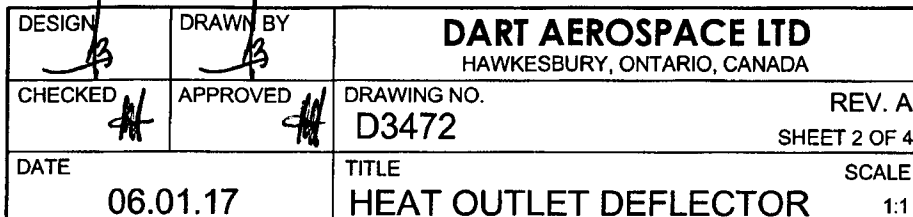
**NOTES:**

- 1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3472-041	CABIN HEAT OUTLET DEFLECTOR
1	D3472-1	FLAP
1	D3472-3	HINGE
4	MS20426AD4-4	RIVET

**COPYRIGHT © 2006 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



## **D3472-1 FLAP BENDING DETAIL**

1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) PART IS SYMMETRICAL ABOUT CENTERLINE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES 0.005 TO 0.010

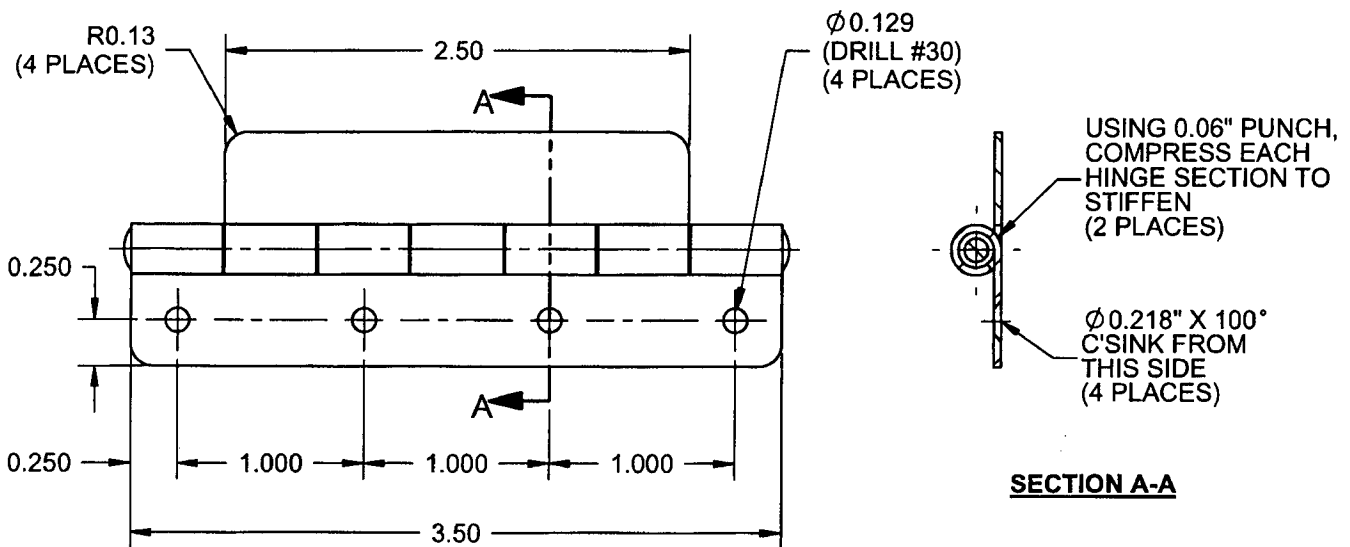
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 34416

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN #	DRAWN BY #	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3472</b>	REV. A SHEET 3 OF 4
DATE <b>06.01.17</b>		TITLE <b>HEAT OUTLET DEFLECTOR</b>	SCALE 1:1

06.04.03 #

**D3472-3 HINGE****NOTES:**

- 1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

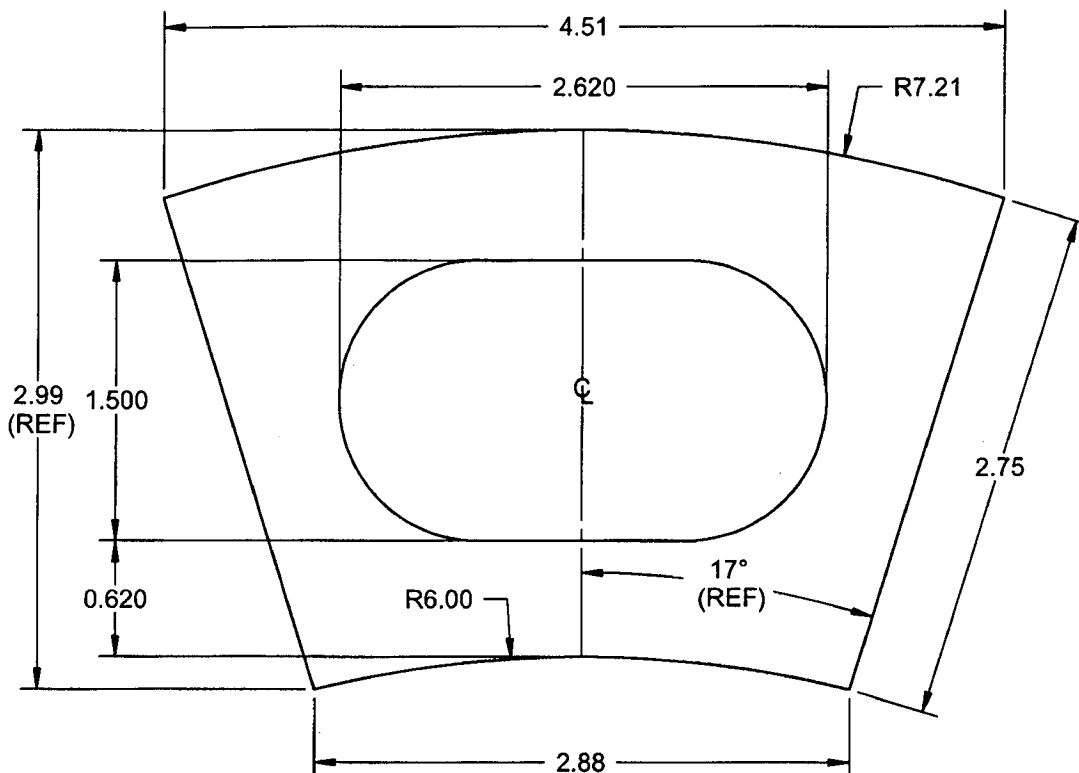
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34416

**COPYRIGHT © 2006 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3472	REV. A SHEET 4 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

06.04.03 *[Signature]***D3472-5 FLAT DOUBLER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING  
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34416*

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



